



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBEM632V3011101
Job Sheet 178184



Part No: RBEM632V3011101

Job Qty: 1 ea

Part Name: Endoscopic Plug Extractor



Part Weight: 0 lbs

Status: At Planning

Priority: Medium

Job Created: 5/28/18

Job Tracking No:

Created By: Logan David

Due Date: 7/16/18

Description:

Type: SOLD

Note: DWG RBEM632V3011101 Rev. 1 IPP Rev. A 18.05.16 new issue DP Verify DD

Ship Via:

*No
DEVIATION*

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		7/16/18	0.00	0.00	Start Up Small Fab-2		
110	Small Fab	1 pcs		7/16/18	0.00	1.00	Small Fab-3		<i>MCC</i>
120	QC	1 pcs		7/16/18	0.00	0.00	QC5		<i>MCC</i>
130	Packaging	1 pcs		7/16/18	0.00	0.00	Packaging3-1		<i>38</i>
140	QC21-SA	1 Ea		7/16/18	0.00	0.00	QC21		<i>9-89</i>

Part Op 110 - 1-Assemble as per DWG 2-Engrave placard RB41011 using MARKTRONIC engraver 3-Transfer drill Dart placard
Descriptions: RB41011 into Pelican case APP-1040-E 4-Deburr holes and remove chips from case. 5-Rivet Dart placard to Pelican
case 6-Pack case as per DWG.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
97524A032	Sealing Blind Rivet	4 Ea (4 ea)	90-Start up Operation	<i>5089128</i>
APP-1040-E	Case	1 pcs (1 ea)	90-Start up Operation	<i>5089646</i>
RB41011	Dart Tooling Placard, Aluminum	1 Ea (1 ea)	90-Start up Operation	<i>5021040</i>
RBEM632V3011101-5	Bottom Foam	1 (1 ea)	90-Start up Operation	<i>5089647</i>
RBEM632V3011101-7	Top Foam	1 (1 ea)	90-Start up Operation	<i>5089648</i>
98002A202	Binding Post	1 Ea (1 ea)	110-Small Fab	<i>5075950</i>
RBEM632V3011101-1	Plier Half	2 Ea (2 ea)	110-Small Fab	<i>5091828</i>

NAS1149C0432B 62260

1 EA

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	97524A032	4	219	0
	APP-1040-E	1	0	0
	RB41011	1	903	0
	RBEM632V3011101-5	1	0	0
	RBEM632V3011101-7	1	0	0
	98002A202	1	0	0
110-Small Fab	RBEM632V3011101-1	2	0	0

17/8/18

Part Specifications

Specifications could not be found.

Plex 5/28/18 2:43 PM dart.logan.david



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Hawkesbury, ON K6A 1K7
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Container No: S109759



Part: RBEM632V3011101

Job No: 178184

Serial No/Batch: S109759

Revision: 1

Inspector:

Exp Date:

Instructions:

Date: 08/13/18

178184

Page 1 of 1

Measured by:		Checked by:		QC Inspector:	
Date:		Date:		Date:	
Engineering Approval: (if necessary)		Date:			
Rev	Date	Change	Revised by		Approved
A	14.07.31	New Issue	KJ		

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

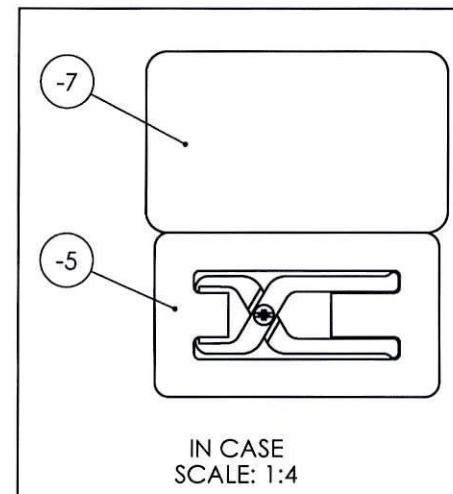
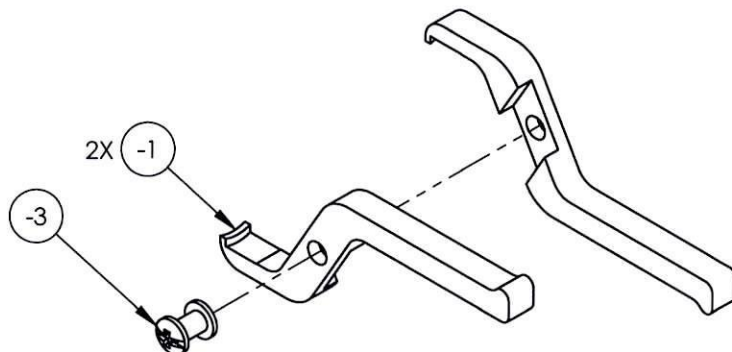
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		RELEASED FOR PRODUCTION.	1/7/2016	DPD	JAG

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 178184
20180712



NOTE:
REFERENCE AIRBUS T/N M632V3011101.

DART AEROSPACE																							
TITLE TOOLING PLIERS																							
DWG NO. RBEM632V3011101	REV 1																						
<table border="1"> <tr> <td>MAT'L</td> <td>UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES</td> </tr> <tr> <td>HEAT TREAT</td> <td>.XXX ± .005 FRACTIONS ± 1/8</td> </tr> <tr> <td>FINISH</td> <td>.XX ± .01 ANGLES ± 5°</td> </tr> <tr> <td></td> <td>.X ± .1 SURFACES = 125/</td> </tr> <tr> <td>SPEC</td> <td>1. BREAK ALL SHARP EDGES .015 x 45° OR .015R</td> </tr> <tr> <td>DRAWN BY: DUERFELDT</td> <td>2. DIMENSIONAL LIMITS APPLY AFTER PLATING</td> </tr> <tr> <td>CHECKED: CLOUGH</td> <td>3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009</td> </tr> <tr> <td>OPPS APPR: ANDERSON</td> <td>USED ON MODEL</td> </tr> <tr> <td>QA APPR: LINDSAY</td> <td>H175</td> </tr> <tr> <td>APPROVED: GILBERT</td> <td></td> </tr> <tr> <td>SCALE 1:2</td> <td>DATE 12/2/2015 SHEET 1 OF 4</td> </tr> </table>		MAT'L	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8	FINISH	.XX ± .01 ANGLES ± 5°		.X ± .1 SURFACES = 125/	SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	DRAWN BY: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING	CHECKED: CLOUGH	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	OPPS APPR: ANDERSON	USED ON MODEL	QA APPR: LINDSAY	H175	APPROVED: GILBERT		SCALE 1:2	DATE 12/2/2015 SHEET 1 OF 4
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ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	2	PLIER HALF	1018/1020 CR		2
		B/O	-3	1	BINDING POST	STEEL	Ø1/4 X 3/8, 10-24 (MCMMASTER-CARR #98002A202)	1
		B/O	-5	1	BOTTOM FOAM	Y20, BLACK	.93 X 3.55 X 6.18 (I.R. SPECIALTY)	3
		B/O	-7	1	TOP FOAM	Y20, BLACK	.75 X 3.93 X 6.56 (I.R. SPECIALTY)	4
		B/O	-9	1	CASE	PLASTIC	#APP-1040-E	N/S
		B/O		1	DART PLACARD	ALUMINUM	RB41011	N/S